

Work Order ID 159874

Wednesday, April 19, 2017 12:17:41 PM

159874

Page 1

Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd
Start Date: 4/23/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100

0.04

100

FLOW WATER JET

Waterjet

Memo

2.73

FLOW CNC Waterjet

1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

(26)

APR 17/04/23

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.25

Quality Control

(26)

APR 17/04/23

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.50

Quality Control

26

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38
APR 24 2017

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793	0.19 1.43			DAS 30 9-89	<u>26</u>			APR 25 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.50				<u>26</u>			DAS 38 9-89 APR 26 2017
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <u>M 136370.</u> Memo START TIME: <u>8:10</u> FINISH TIME: <u>8:40</u>	0.00 0.82				<u>26</u>	<u>05-1</u> <u>17-04-28.</u>		DAS 34

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Item ID: D3793-1 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 4/23/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.25							
Quality Control									

170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170									
Packaging	Memo	0.25							
Packaging	LOCATION ; FP002								

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.50							
Quality Control									

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9-88

MAY 02 2017

Picklist Print

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Work Order ID: 159874

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Parent Item: D3793-1

D3793-1

Parent Item Name: Wearplate Fwd

Start Date: 4/23/2017

Required Date: 5/2/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	109.1300	0.5902	15.53158			

M304S20GA

304/316 .040 Sheet

02/17/04/23

Location

Loc Qty

Loc Code

MAT020

109.13

m136327

5.55

m136568

6.58

m137041

33

m137263

64

8
12

DART AEROSPACE LTD		Work Order: 159874
Description: Wearshoe		Part Number: D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

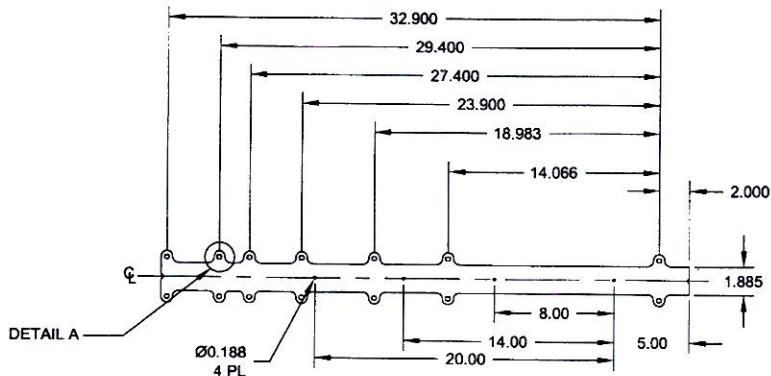
☒ **First Article**

 ☐ **Prototype**

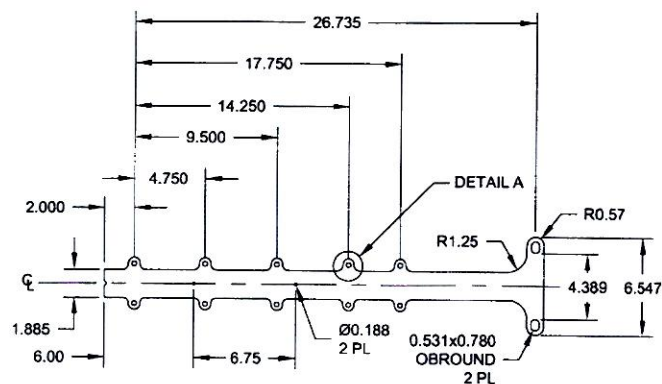
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190	/			
0.300 x 0.300	+/-0.010	0.30 x 0.30	/			
1.885	+/-0.010	1.894	/			
2.000	+/-0.010	2.003	/			
5.00	+/-0.030	5.00	/			
8.00	+/-0.030	8.00	/			
14.00	+/-0.030	14.00	/			
20.00	+/-0.030	20.00	/			
14.066	+/-0.010	14.066	/			
18.983	+/-0.010	18.983	/			
23.900	+/-0.010	23.900	/			
27.400	+/-0.010	27.400	/			
29.400	+/-0.010	29.400	/			
32.900	+/-0.010	32.900	/			
0.040	+/-0.010	0.036	/			

Measured by: DL	Audited by: DAS	Prototype Approval: N/A
Date: 17/04/23	Date: APR 24 2017	Date: N/A

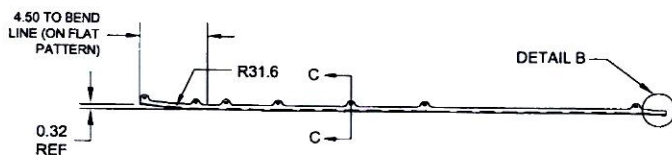
Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159874 M-5
1704-19

RELEASED
08-05-14

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC PORT HADLOCK, WA		REV. A
DRAWING NO.	D3793	SHEET 1 OF 2
TITLE	WEARSHOE	SCALE
		NTS

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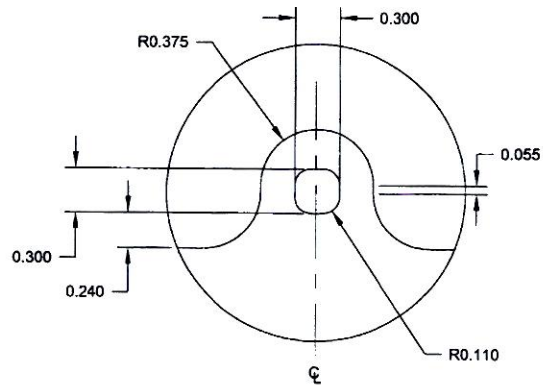
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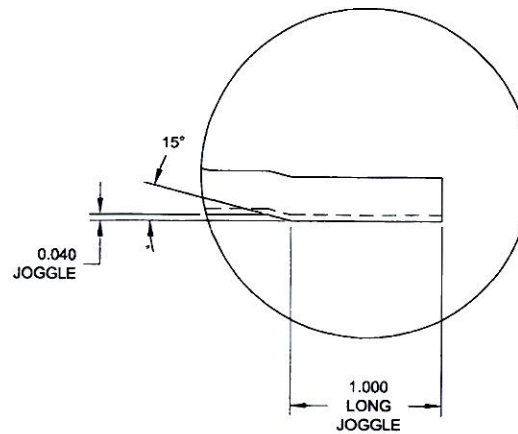
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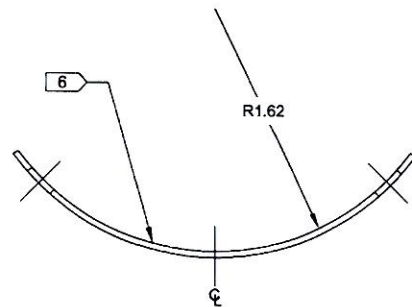
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DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

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08-05-23/102

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE	NTS
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